

Date: Wednesday, 1/23/2008 11:34:01 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	FUEL SCUPPER ASSEMBLY
Job Number	36917A		
Estimate Number	10152		
P.O. Number	:	Part Number	: D3270041
This Issue	: 1/23/2008	S.O. No.	: D3270 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Type	: LARGE FAB ASSY
Previous Run	: 24076A	Drawing Revision	: B
Written By	:	Material	:
Checked & Approved By	: <u>HK 08-01-23</u>	Due Date	: 2/29/2008
Comment	: Est Rev:A New Issue 05-11-01 JLM	Qty:	20
Um:	Each		
Additional Product			
Job Number:		Description :	
Seq. #:	Machine Or Operation:	Description :	
1.0	36917A01		
2.0	M6061T6T0375W035	6061-T6 Tube .375 x.035W	
Comment:	Qty.: 0.6999 f(s)/Unit Total : 13.9986 f(s)		
Material:	6061-T6 (QQ-A-200/8 or QQ-A-225/8) 0.375 OD x 0.035" wall(M6061T6T0.375W.035)		
Identify as	D3270-3		
Batch:	<u>M104913x8 / M104921x12</u>		<u>FF 08-01-30</u>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment:	SMALL & MEDIUM FAB RESOURCE 1		
Cut D3270-3 as per Dwg D3270			<u>FF 08-01-30</u>
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
Comment:	LARGE FABRICATION RESOURCE 1		
Weld D3270-3 to D3270-1 as per Dwg D3270 using welding Jig D3270-041T1 and QSI 004.			<u>SAD 08/03/01 20</u>
5.0	QC9	VISUAL WELDING INSPECTION	
Comment:	VISUAL WELDING INSPECTION		<u>10/04/01 (20)</u>
6.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment:	INSPECT WORK TO CURRENT STEP		<u>08/04/01 (20)</u>
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment:	HAND FINISHING RESOURCE #1		
Chemical Conversion Coat as per QSI 005 4.1			<u>08-04-01 (20)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL SCUPPER ASSEMBLY

Job Number: 36917A

Part Number: D3270041

Job Number:



Seq. #: Machine Or Operation:

Description :

8.0 POWDER COATING

POWDER COATING



M107550



(20X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-f 08/04/01

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HY



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-02

(20X)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/08 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



m-f 08-04-08

W

(20)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

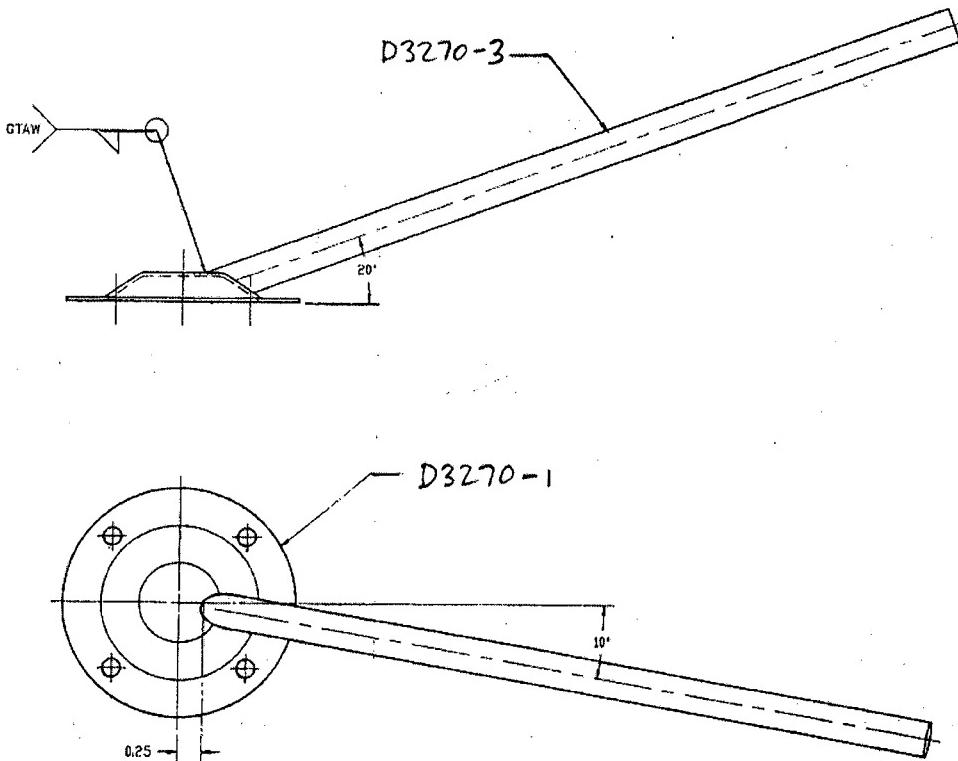
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

COPY ISSUED

DESIGN <i>#</i>	DRAWN BY <i>#</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>GP</i>	APPROVED <i>#</i>	DRAWING NO. D3270	REV. B SHEET 1 OF 2
DATE 05.07.14		TITLE FUEL SCUPPER DRAIN ASSEMBLY	SCALE NTS
A	04.02.20	NEW ISSUE	
B	05.07.14	ADD D3270-1 FLAT PATTERN	

RELEASED
04.02.23 *#*D3270-041 FUEL SCUPPER ASSEMBLY

- NOTES:
- 1) WELD PER DART QSI 004 USING 5356 FILLER ROD.
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER QSI 005 4.3
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) CONTOUR MAY BE ALTERED TO DOMED SHAPE AT FABRICATOR'S DISCRETION

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WITHOUT NOTICE

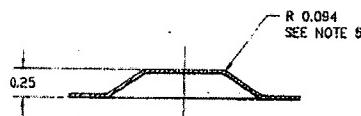
WORK ORDER
NO. 36917A

DART

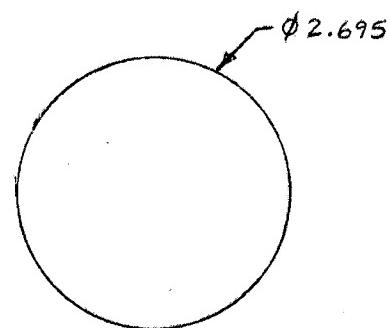
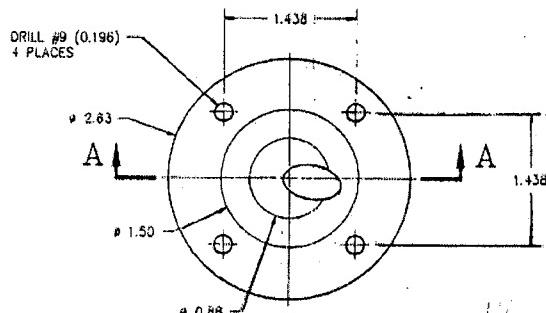
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3270
DATE		TITLE
05.07.14		FUEL SCUPPER ASSEMBLY
		SCALE
		NTS
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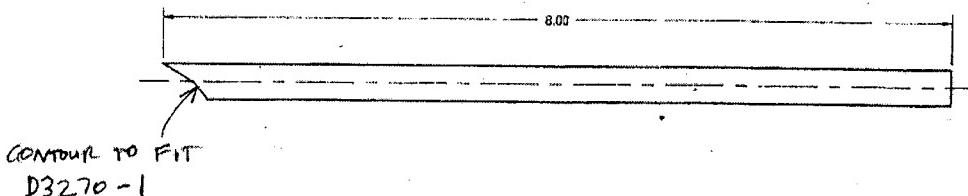
04.02.23



SECTION A-A

D3270-1 MOUNTING BASE

MATERIAL: 6061-T6 ALUMINUM SHEET 0.040" THICK PER QQ-A-250/11 (M6061T6S.040)



* 0.375
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 WORK ORDER 36917A

D3270-3 FUEL OUTLET TUBE

MATERIAL: 6061-T6 ALUMINUM TUBING 0.375" OD X 0.035" WALL (SEAMLESS)
 PER MN-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
 (M6061T6T0.375W.035)

